

**IN THE CLAIMS**

Please amend the claims as follows:

**Claims 1- 15 (Cancelled)**

16. (Currently Amended) A ~~process for casting a~~ workpiece, ~~in particular an internally cooled turbine blade or vane, in which casting cores (2) are introduced~~ produced by the process, comprising:

introducing casting cores into a casting cavity-(1), ; and  
producing passages-(3)- from the casting cores, which pass through the workpiece, ~~in particular having the features of one or more of claims 1 to 15, characterized in that~~ wherein the casting cores (2) are introduced into the casting cavity (1) in such a manner that they rest loosely against one another.

17. (Currently Amended) The ~~process~~ workpiece as claimed in claim 16, ~~characterized in that~~ wherein the casting cores (2) ~~which have been~~ introduced into the casting activity (1) are subsequently coated with a material which can withstand casting and bonds to them.

**Claims 18- 20 (Cancelled)**

21. (New) A workpiece as claimed in claim 16, wherein the workpiece is an internally cooled turbine blade.

22. (New) A workpiece as claimed in claim 16, wherein the workpiece is an internally cooled turbine vane.

23. (New) A workpiece as claimed in claim 17, wherein the workpiece is an internally cooled turbine blade.

24. (New) A workpiece as claimed in claim 17, wherein the workpiece is an internally cooled turbine vane.

25. (New) A workpiece as claimed in claim 16, wherein the passages pass through the workpiece in the form of a three-dimensional grid.

26. (New) The workpiece as claimed in claim 16, wherein passage openings have diameters of between approximately 0.1 and approximately 2 mm.

27. (New) A casted workpiece, comprising:  
a wall including passages in the form of a three-dimensional grid, whereby a casted three-dimensional grid coating of the passages is one piece with the remainder of the workpiece.

28. (New) The workpiece as claimed in claim 27, wherein practically a quarter of the total area of a workpiece side is made up by an area of uniformly distributed passage openings.

29. (New) A workpiece as claimed in claim 27, wherein the workpiece is an internally cooled turbine blade.

30. (New) A workpiece as claimed in claim 27, wherein the workpiece is an internally cooled turbine vane.

31. (New) A workpiece as claimed in claim 28, wherein the workpiece is an internally cooled turbine blade.

32. (New) A workpiece as claimed in claim 28, wherein the workpiece is an internally cooled turbine vane.

33.     **(New)** The workpiece as claimed in claim 27, wherein passage openings have diameters of between approximately 0.1 and approximately 2 mm.

34.     **(New)** The workpiece as claimed in claim 28, wherein passage openings have diameters of between approximately 0.1 and approximately 2 mm.